

Shp ASAP 6

Work Order ID 69490

Wednesday, May 11, 2011 12:57:23 PM



Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 11-05-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	A								
D4020	A								

100

Weld per dwg A/R S.S. rod Batch: M115778 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3913 using DT9610A
 inspect before welding mesh
 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket

Handwritten: 11.07.27

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

Handwritten: 11.07.28 1 0 BE 1/57/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

11 07 28 ①

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BH 11-7-29

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

11-7-7745.

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 8:35

OVEN TEMPERATURE: 400

FINISH TIME: 9:05

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 10:35

OVEN TEMPERATURE: 400

FINISH TIME: 11:05

1 BL 11-7-29.

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 11/08/02 D

W/O:		WORK ORDER CHANGES					
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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

GP 5/10/08/02 @

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*5 u108605**(+)*

170

Identify as per dwg & Stock Location: *GA*

0.00



Packaging

Memo

0.00

Packaging

*W/O
69485**GP 5/10/08/02 @*

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Reference:

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/05

11-08-5

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Picklist Print

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Page 1

Work Order ID: 69490

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011

Required Date: 5/13/2011





Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581  Mounting Bracket		Manufactured	No			100	Each	38.0000	2	2		11.07.27	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				38					
					68964			38					
D3913-1  Rib		Manufactured	No			100	Each	4.0000	1	1		11.07.25	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
					69260			2					
				WA006				2					
					68418			2					
D3913-15  Wide Handle Plate		Manufactured	No			100	Each	1.0000	1	1		11.07.25	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				1					
					68176			1					
D3913-3  Rib		Manufactured	No			100	Each	1.0000	1	1		11.07.25	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA006				1					
					68185			1					

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Work Order ID: 69490

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-7 Manufactured No

100 Each

8.0000

2

2



Rib

B70334

(2)



11.07.25

Location

Loc Qty

Loc Code

WA006

8

65278

1

66435

1

68417

6

D3913-9 Manufactured No

100 Each

4.0000

1

1



Hinge Rib

B70336

(1)



11.07.25

Location

Loc Qty

Loc Code

WA006

4

68186

1

68590

3

D3916-041 Manufactured No

100 Each

4.0000

2

2



Rib Assembly

B71282

(2)



11.07.25

Location

Loc Qty

Loc Code

WA

4

68538

4

D3916-5 Manufactured No

100 Each

4.0000

3

3



Light Rib

B69076

(3)



11.07.25

Location

Loc Qty

Loc Code

WA006

4

68155

4

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Page 2

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Page 3

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-1

Manufactured No

100

Each

28.0000

3

3



Hinge Half, Base

70342

3



11.07.27

Location

Loc Qty

Loc Code

WA

28

66418

0

67473

10

68426

18

D4017-7

Manufactured No

100

Each

5.0000

1

1



Rib

B71944

1



11.07.25

Location

Loc Qty

Loc Code

WA

5

68415

2

69009

3

D4017-9

Manufactured No

100

Each

10.0000

2

2



Rib

B71742

2



11.07.25

Location

Loc Qty

Loc Code

WA

6

69011

6

WA006

4

68416

4

D4020-11

Manufactured No

100

Each

2.0000

2

2



End Mesh, Basket

Location

Loc Qty

Loc Code

WA

2

67458

2

71725

2



11.07.27

Wednesday, May 11, 2011 12:57:31 PM

Shop Packet Print

Page 3

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Page 4

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-1 Manufactured No

100

Each

10.0000

3

3



Handle Plate

B09777

(3)



11.07.25

Location

Loc Qty

Loc Code

WA

10

68424

10

D4034-041 Manufactured No

100

Each

0.0000

1



Aft Upper Rib Assembly

B71483

(1)



11.07.25

D4034-043 Manufactured No

100

Each

2.0000

1

1



Fwd Upper Rib Assembly

B71955

(1)



11.07.25

Location

Loc Qty

Loc Code

WA

2

69155

2

M304EX0.75-16F Purchased No

100

sf

518.0152

33

33



Expanded Metal Flat SS

M118248

(33)



11.07.25

Location

Loc Qty

Loc Code

WA

518.0152

115012

114

117197

182.3016

117455

221.7136

AN3-10A Purchased No

150

Each

77.0000

6

6



Bolt

Location

Loc Qty

Loc Code

ST351

77

117313

77



5/11/08/02

6

Wednesday, May 11, 2011 12:57:31 PM

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Page 4

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD8 NAS1149DN832J Purchased No

150 Each

0.0000

2



Washer

D2931

Manufactured No

150 Each

676.0000

2



Bumper

Location

Loc Qty

Loc Code

ST504

676

46064

676

150 Each

12.0000

2

D4021-5

Manufactured No



Blanking Plate

Location

Loc Qty

Loc Code

ST110

10

68261

10

WA005

2

67008

2

150 Each

1,375.000

2

MS20600-AD4W3

Purchased No



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1050

111636

350

117505

500

117601

200

WA018

325

107939

325

13

Wednesday, May 11, 2011 12:57:31 PM

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

2,328.000

6



Nut

Location

Loc Qty

Loc Code

ST300

2328

116391

11

116540

351

116549

766

117441

800

117601

400



6
5/11/08/02

NAS1149F0332P

Purchased

No

150

Each

100.0000

12



WASHER

Location

Loc Qty

Loc Code

ST275

100

17317

100



12
5/11/08/02

M118354 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

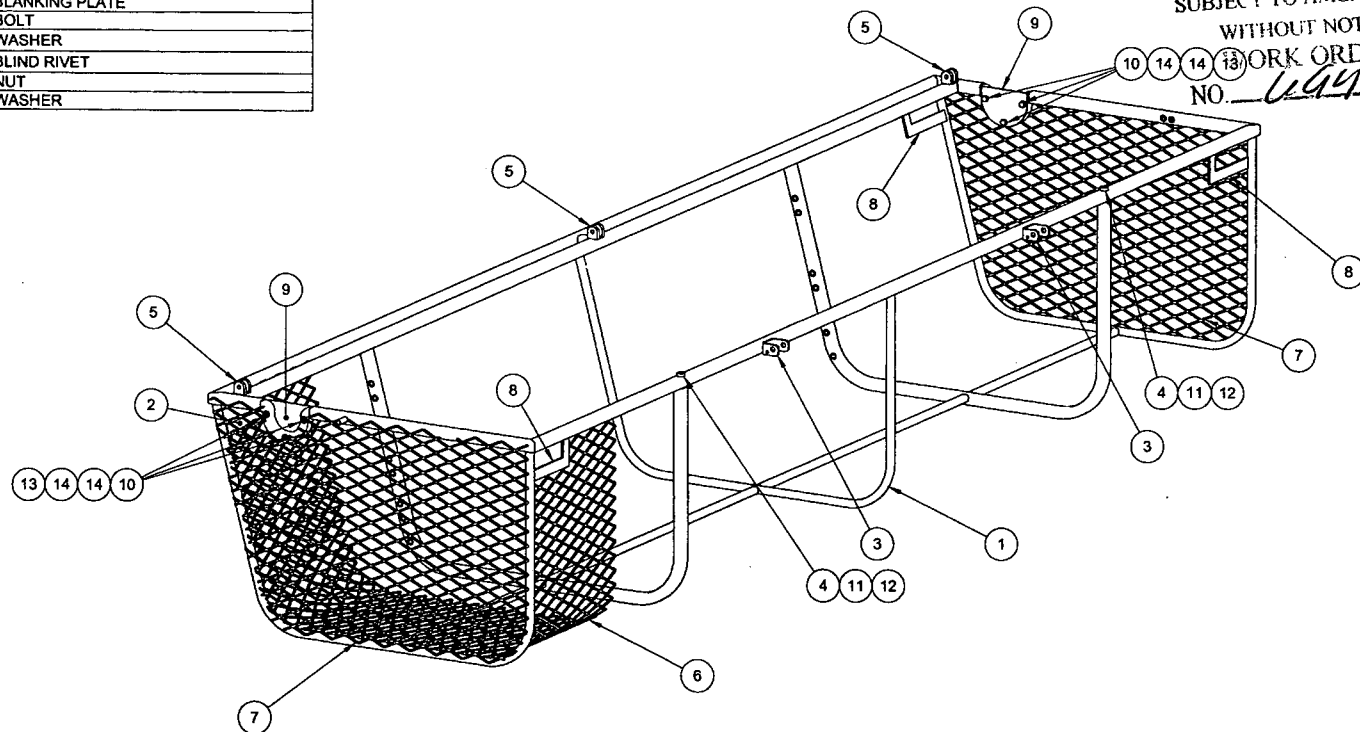
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64490
2/11-05-11

RELEASED
2010-03-22
WJD

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3913 TITLE LONG BASKET BASE ASSY (350) REV. A SHEET 1 OF 6 SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

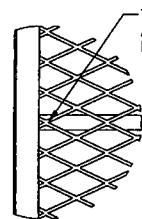
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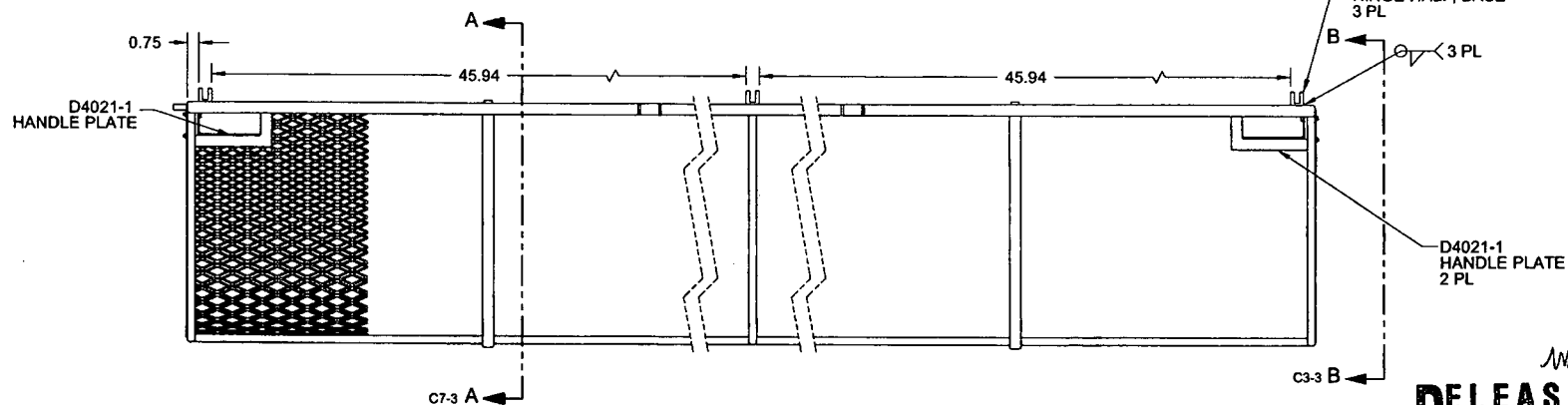
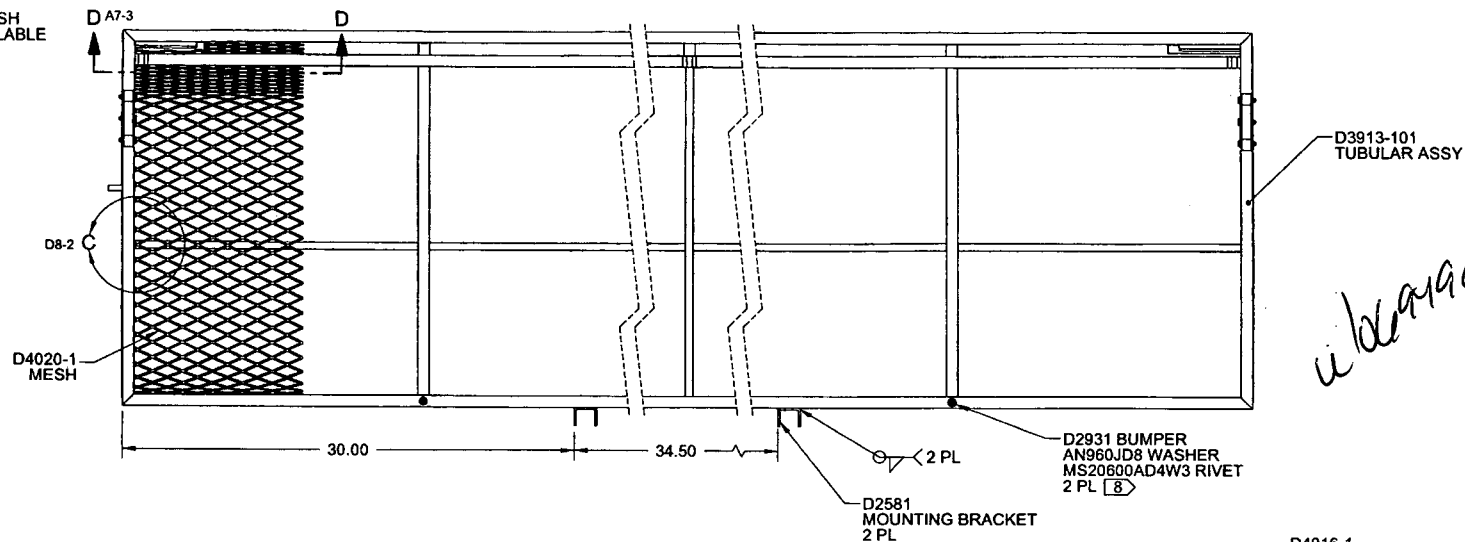
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NOTE: Date & initial all entries



DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

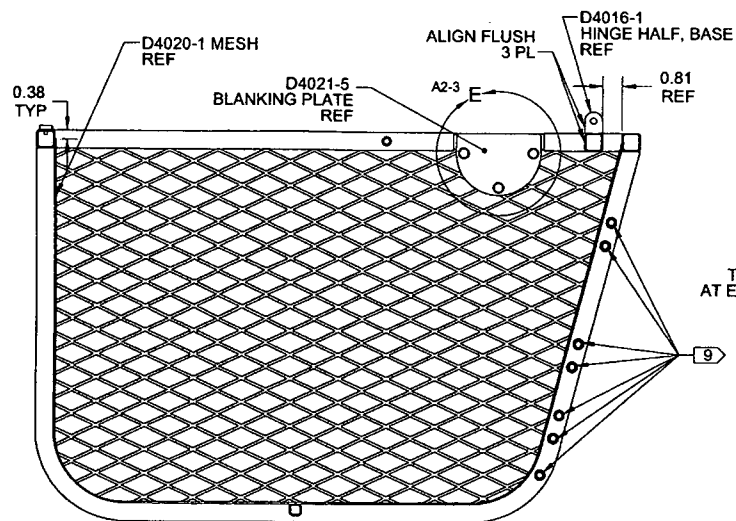
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

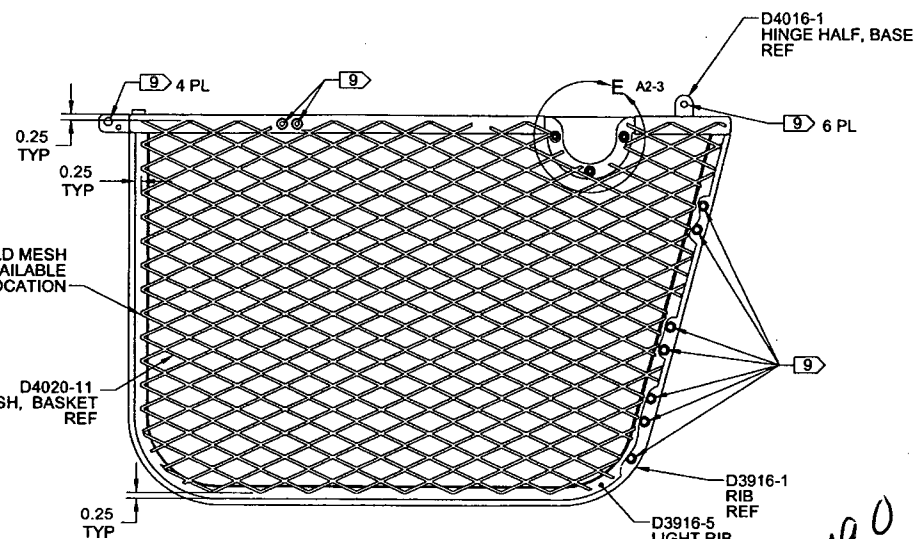
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

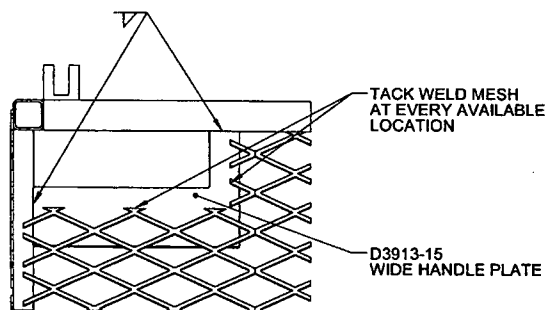
NOTE: Date & initial all entries



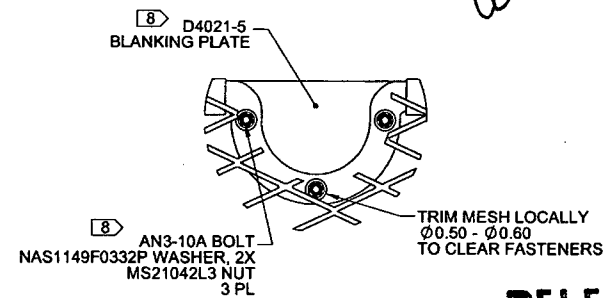
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	AK	D3913	SHEET 3 OF 6
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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2010-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

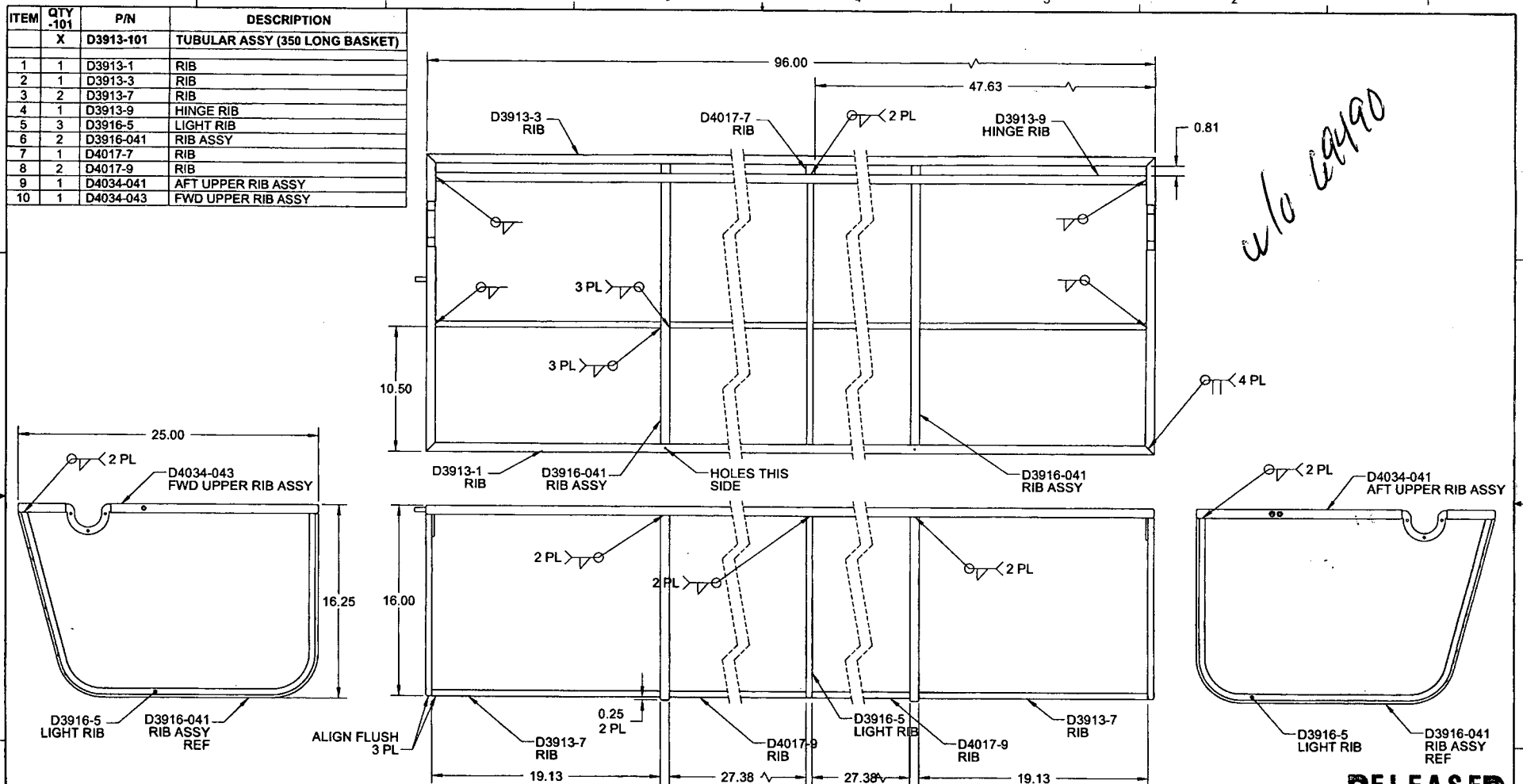
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ±0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D3913	REV. A
MFG. APPR.		TITLE LONG BASKET BASE ASSY (350) NTS	SHEET 4 OF 6
APPROVED		SCALE	
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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2010-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

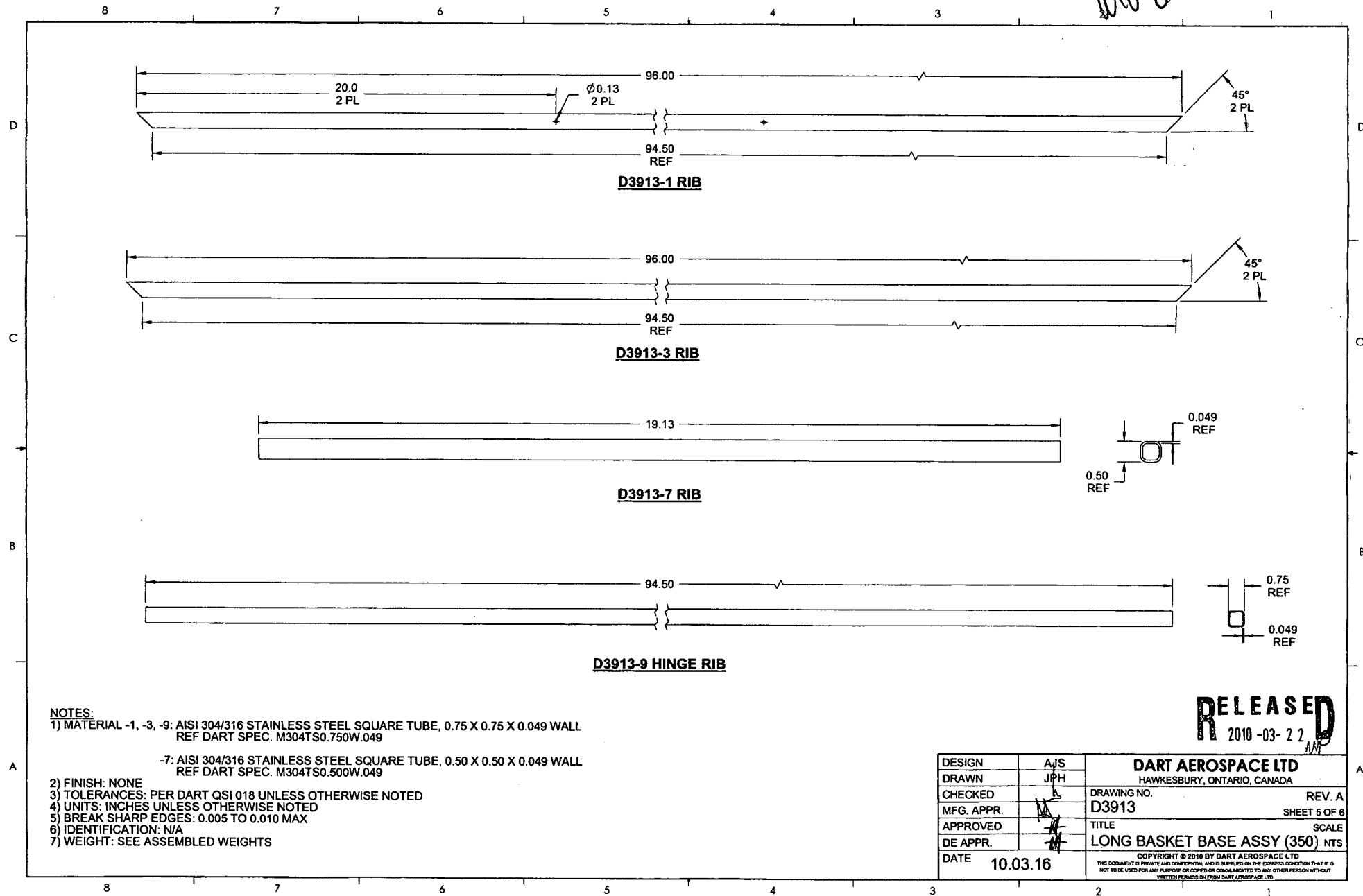
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

who 69490



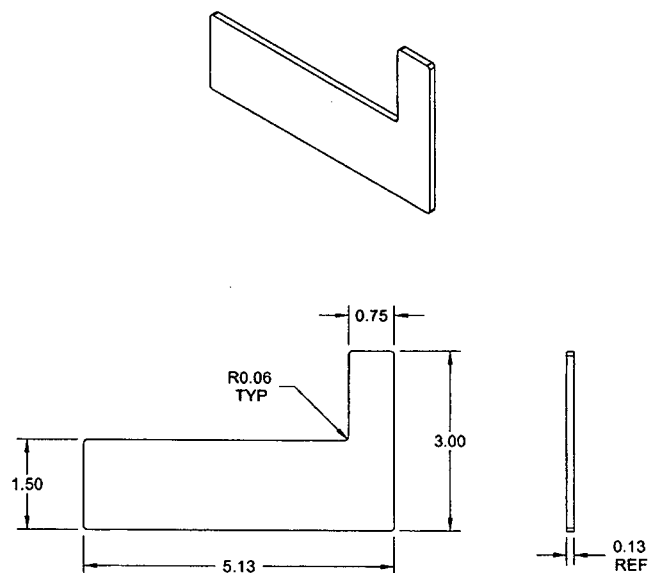
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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R 2010-03-22
JRP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries